

Work Order ID 74255

Page 1

Tuesday, September 27, 2011 1:06:28 PM

Item ID: D4131-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Front Plate

Start Date: 9/27/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 10/6/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D4131

B

100

0.00



Waterjet

0.00

FLOW CNC Waterjet

304 . 050

Memo

1-Cut as per Dwg

Dwg Rev: BProg Rev: B

2-Deburr if necessary

B11-9-27

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

0.00

Quality Control

Memo

B11-9-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

[illegible]

Page 2

Accept

[illegible]**Setup Start**

Stop

[illegible]**Cust Item ID:**

Abstract

Customer:

Reference:

Run Start

Approvals: _____ **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Set Up/ Run Hours

Tool ID

Tool #

Plan Code

Accept

Qty

Reject
Qty

Reject Number

**Insp.
Stamp**

QC8- Inspect parts - second check

0.00

[REDACTED]

QC

Memo

0.00

Quality Control

Identify as per dwg & Stock Location: ST 131

0.00



Packaging

Memo

0.00

Packaging

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

11/9/28 *[Signature]*
mr
 11-09-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, September 27, 2011 1:06:25 PM

Page 1

Work Order ID: 74255

Parent Item: D4131-1

Parent Item Name: Front Plate



Start Date: 9/27/2011

Required Date: 10/6/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A 10.10.06 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304S18GA

Purchased

No

100

sf

288.0050

0.1807

1.902105

2.2



304/316 .050.Sheet



1811-9-27

Location

Loc Qty

Loc Code

MAT020

288.005

113062

0.005

119032

288

119032

(12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

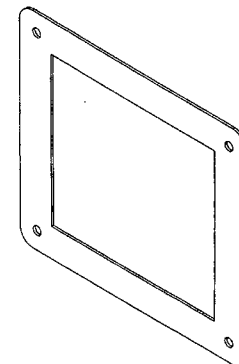
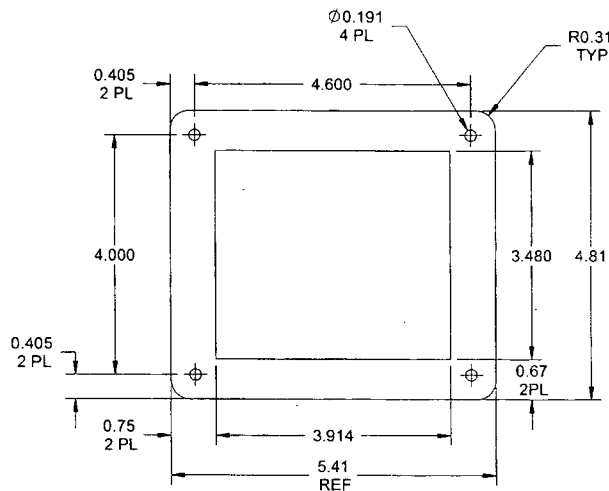
DART AEROSPACE LTD		Work Order: 74255
Description: Front Plate		Part Number: D4131-1
Inspection Dwg: D4131	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.191	+0.005/-0.001	.192	✓		VIB02	
0.405	+/-0.010	.406	✓		V	
4.600	+/-0.010	4.601	✓		V	
3.480	+/-0.010	3.474	✓		V	
4.81	+/-0.030	4.807	✓		V	
0.67	+/-0.030	.689	✓		V	
5.41	+/-0.030	5.419	✓		V	
3.914	+/-0.010	3.907	✓		V	
0.75	+/-0.030	.762	✓		V	
0.405	+/-0.010	.405	✓		V	
4.000	+/-0.010	3.998	✓		V	
0.050	+/-0.010	.047	✓		V	

Measured by: B	Audited by: S	Preliminary Approval:
Date: 11-9-27	Date: 11/09/28	Date:

Rev	Date	Change	Revised by	Approved
A	10.10.25	New Issue	KJ	A



D4131-1 FRONT PLATE

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL ANNEALED 2B FINISH 0.050 (18 GAUGE) SHEET
PER MIL-S-5059
OR AMS 5513 (304)
OR AMS 5524 (316)
OR ASTM A240
OR ASME SA240
PER DART SPEC. M304S18GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.18 lbs

DESIGN	RF	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	RF		
CHECKED	<i>RF</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>RF</i>	D4131	SHEET 5 OF 10
APPROVED	<i>RF</i>	TITLE	SCALE
DE APPR.	<i>RF</i>	MANIFOLD ASSEMBLY	NTS
DATE	11.07.27	<small>COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

RELEASED
2011-09-21
NT

W/6740255